

Work Order ID 84261

84261

Page 1

July-06-12 10:22:36 AM

Item ID: D206-667-101

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Fwd

Start Date: 5/08/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/28/12 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D206-667-141	Rev. C (DEO)
DSI9565	A

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP D206-667-101 CHG004

DSI9565

110

0.00

110

Packaging

Packaging

Memo

0.00

Packaging

1 DSI MLJ 12-11-6

12-10-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 Required Date: 5/28/12 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	BENDING MACHINE - CROSSTUBES	0.00							
120									
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Bend tube as per Dwg D206-667-141 using CNC bender program 206B-fw and Folio FT _____								
130	QC15- Crosstube Dimensional Check	0.00							
130									
QC	Memo	0.00							
Quality Control									

DP *12-10-25*

DAS
16
12/10/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item ID: D206-667-101

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Crosstube Fwd

Start Date: 5/08/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/28/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00

140

Crosstubes

0.00

Crosstubes

Crosstubes

Memo

1-Drill holes & ream using drill Jig DT8541 & DT8542 as per Dwg D206-667-141. Drill all (3) top holes.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8541 & DT8542 as per Dwg D206-667-141. Drill only the top (2) holes.

5-Drill pilot holes as per Dwg D206-667-141. Drill only the top (2) holes.

6-Drill Fwd rivet holes using drill Jig DT8787FWD as per Dwg D206-667-141. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8787AFT as per Dwg D206-667-141.

8-C'sink holes as per Dwg D206-667-141. Allow rivet to sit below surface to compensate for paint.

9-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-141 Inside of Cuff(Do not engrave on outside of tube)

10-*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***
Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-141

mo 12/10/29
TW

mo 12/10/29

~~mo 12/10/29~~

RM 12-10-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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1

Cust Item ID:

Required Date: 5/28/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control	*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***								
160		0.00							
160									
HandFXtube	Memo	0.00							
Hand Finishing Crosstubes	*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***								
	1- CLEAN CROSSTUBE WITH WASH'N WIPE								
180	Outsource process - NDT per QSI038 4.1	0.00							
180									
Outsource2	Memo	0.00							
Outsource process - NDT	*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***								
	Liquid Penetrant Inspection as per QSI 038Or Issue P/O: <u>18282</u> LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order								

W/O:		WORK ORDER CHANGES					
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 Required Date: 5/28/12 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Packaging	0.00							
190									
Packaging	Memo	0.00							
Packaging	*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***								
	Ensure copy of NDT results attached to work order.								
200	QC5- Inspect part completeness to step on W/O	0.00							
200									
QC	Memo	0.00							
Quality Control	*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***								
	Inspect for damage & ensure results are as per Dwg D206-667-103								
202		0.00							
202									
HandFXtube	Memo	0.00							
Hand Finishing Crosstubes	*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***								
	1- PRESSURE WASH AND THEN USE WASH'N WIPE TO CLEAN CROSSTUBE BEFORE CHEMICAL CONVERSION								

DAS 16 12/10/30

12/10/30

1 0 0 AS 12-10-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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205	QC7-Inspect Chemical Conversion Coat	0.00							
205									
QC	Memo	0.00							
Quality Control	*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***								

210	SprayPaint	0.00							
210									
SprayPaint	Memo	0.00							
Spray Painting	*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***								

1-Prime inside and outside crosstube as per QSI 005 4.2.1
 *****Let tube sit up right for 30mins before hanging*****

P4500-P-23 Base Batch: 122 888
 P4500-C-23 Catalist Batch: 122 888

Start time: 12:30 Finish: 1:00

DAS 16
9-11-12
filed 30

DSI 9544
mask for wraps h

1 *0* *0* *AD*
12-10-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	SprayPaint	0.00							
230									
SprayPaint	Memo	0.00							
Spray Painting	*** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***								
	1-Paint outside crosstube with White Imron as per QSI 005								
	4.2								
	Imron 55U white paint	Batch: 123307							
	Imron 125S activator	Batch: 123307							
	Start: 5:05								
240	QC14- Inspect Spray Paint	0.00							
240									
QC	Memo	0.00							
Quality Control									

DAS
16
17/10/31

12-10-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Revision ID:

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Start Date: 5/08/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/28/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250		0.00							
250	Crosstubes					<u>1</u>	<u>0</u>	<u>0</u>	<u>AB</u>
Crosstubes	Memo	0.00							<u>12-10-31</u>
Crosstubes	1-Abrade mating surfaces of support and crosstube with 400 grit sandpaper, clean the area with 4105S wash 'n' wipe								
	2-Install supports with Proseal 890 per DSI9565 and QSI 015 A/R Proseal 890 Batch: <u>123103</u>								
	3- Torque bolts as per dwg								
	3-Install nut plates as per Dwg D206-667-141. Touch-up rivet heads with Imron paint.								
260	QC5- Inspect part completeness to step on W/O	0.00							
260									
QC	Memo	0.00							
Quality Control									

DAS
11
2-89

12-11-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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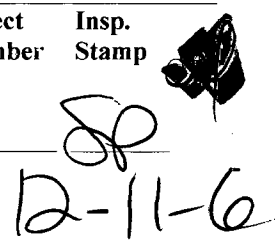
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July-06-12 10:22:36 AM

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	Pick Kit	0.00				1X			
270									
Packaging	Memo	0.00							
Packaging									
280	QC4- 100% Inspect kits for completeness	0.00				1			
280									
QC	Memo	0.00							
Quality Control									
290		0.00							
290									
Packaging	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-667-101								
	Location: _____								
	PPP Rev: _____								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300	QC21- Final Inspection - Work Order Release	0.00							
300									
QC	Memo	0.00							
Quality Control									

12/11/80
W121107

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

May-08-12 2:41:50 PM

Page 1

Work Order ID: 84261

84261

Parent Item: D206-667-101

D206-667-101

Parent Item Name: Crosstube Fwd

Start Date: 08/05/2012

Required Date: 28/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:F05.09.01Add holes for compatibility with Bell SkidtubesKJ/JLM
IPP Rev:G 08-06-03 update as per DS19415 (ECN1198) DD verified by:ec
IPP Rev:H 08-07-28 update as per (par 08-013) DD verified by:EC
IPP Rev J 09.01.06 Per ECN 08-562 EC verified by:DD IPP REV:K
11.08.05 PER ECN 11-615 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2873-043		Manufactured	No			250	Each	52.0000	2	2			
D2873-043													
Nut Plate Assembly													
**													
AR 12-10-31													

Location	Loc Qty	Loc Code
LG052	52	
72644	2	
81502	10	
82949	40	

D2873-045		Manufactured	No			250	Each	45.0000	2	2			
D2873-045													
Nut Plate Assembly													
**													
AR 12-10-31													

Location	Loc Qty	Loc Code
LG052	45	
81425	5	
82947	40	

D2891-1		Manufactured	No			250	Each	22.0000	2	2			
D2891-1													
2.25 Support													
**													
AR 12-10-31													

Location	Loc Qty	Loc Code
LG052	22	
72822	1	
75176	1	
80160	1	
82277	19	

D206.667.017

92493

X/

①

AR 12-11-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D206-667-101

D206-667-101

Parent Item Name: Crosstube Fwd

Start Date: 08/05/2012

Required Date: 28/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3595-063-395

Manufactured No

250

Each

58.0000

4

4

D3595-063-395

RUBBER CUSHION

**

AS 12-10-31

(4)

Location

Loc Qty

Loc Code

LG051

58

82223

58

MS20601-AD4W8

Purchased

No

250

Each

86.0000

14

14

MS20601-AD4W8

RIVET

**

AS 12-10-31

14

Location

Loc Qty

Loc Code

LG051

47

121017

47

ST322

39

121255

39

AN5-30A

Purchased

No

270

Each

77.0000

4

AN5-30A

BOLT

**

m 122141

SP 12-11-6

Location

Loc Qty

Loc Code

ST339

77

117514

7

120423

15

120910

25

121259

30

May-08-12 2:41:50 PM

Shop Packet Print

Page 2

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D206-667-101

Parent Item Name: Crosstube Fwd

Start Date: 08/05/2012

Required Date: 28/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN5-32A

Purchased

No

270

Each

288.0000

4

AN5-32A

Bolt

**

m122993 sp

SmB

Location

Loc Qty

Loc Code

ST339

188

119328

23

119862

50

120423

75

120910

30

121415

10

ST340

100

121541

100

AN5-7A

Purchased

No

270

Each

2,599.000

10

AN5-7A

Bolt

**

sp

SmB

Location

Loc Qty

Loc Code

ST337

2599

119017

2599

AN960JD516

NAS1149D0563J

Purchased

No

270

Each

0.0000

18

AN960JD516

Washer

**

m123355 sp

MS21042L5

Purchased

No

270

Each

1,655.000

4

MS21042L5

Nut

**

m122452 sp

SmB

Location

Loc Qty

Loc Code

300

500

121652

500

ST300

1155

116105

5

116548

43

117611

30

119109

1077

May-08-12 2:41:50 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-08-12 2:41:50 PM

Work Order ID: 84261

84261

Parent Item: D206-667-101

D206-667-101

Parent Item Name: Crosstube Fwd

Start Date: 08/05/2012

Required Date: 28/05/2012

Start Qty: 1.00

Required Qty: 1.00

MS21920-20

Purchased

No

270

Each

116.0000

4

4

MS21920-20

Clamp (per MIL-DTL-8783C)

**

①
③

AS 12-10-31

Location

Loc Qty

Loc Code

LG050

116

116799

8

120676

12

121067

46

121274

50

D206-667-101TRN

Manufactured

No

110

Each

0.0000

1

1

D206-667-101TRN

Crosstube Turning Detail

**

SAD 12-10-25

B 88978 X 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

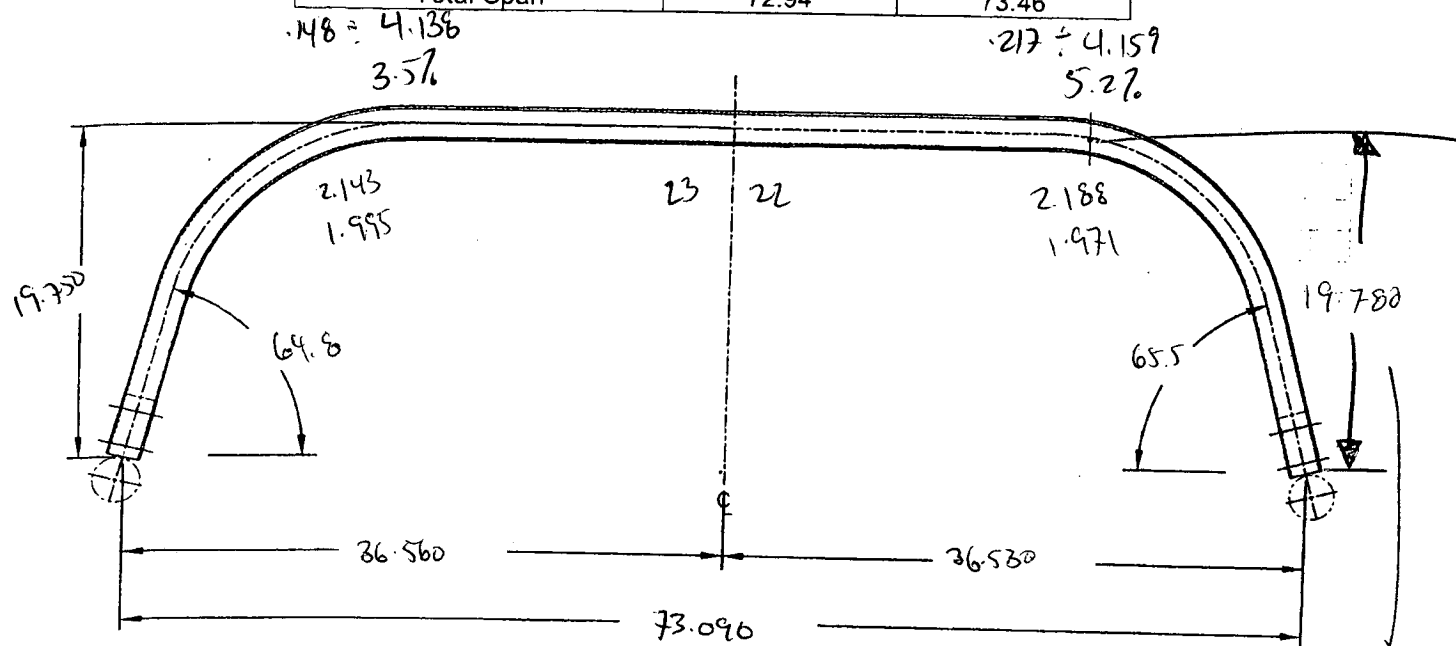
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	84261
Description: Crosstube High Fwd (206B)		Part Number:	D206-667-101
Inspection Dwg: D206-667-141 Rev: C		Page 1 of 1	

Required Dimension	Min	Max
Height	19.41	19.67
1/2 Span	36.47	36.73
Angle	65	67
Total Span	72.94	73.46



Comments	
Size A2	3.57% crush @ 23 Passes
Size B2	5.27% crush @ 22 Passes

QC15 Inspection	
Date	12/10/25

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	09.07.30	Dimensions revised per Dwg Rev C	KJ	

WORK ORDER CHANGES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. C AND EARLIER AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-667 REV. 2 AND EARLIER

REF: CANADIAN STC: SH01-5
REF: FAA STC: SR01304NY
REF: EASA STC: EASA.IM.R.S.01179

PURPOSE

The purpose of this service instruction is to add the optional D206-667-017 Kit and provide guidelines to install extra clamps on D206-667-101/-103 or D407-667-105 forward crosstubes to allow fastening of OEM grounding straps.

INSTRUCTIONS:

- 1) If installed, follow Section 32.1 of ICA-D206-667 for removal of the forward crosstube from the helicopter.
- 2) Locate AN742D36 Clamp as shown in Figure 1 of this service instruction and mark location of clamp on the crosstube.
- 3) Remove crosstube finish (paint and primer) in area where AN742D36 Clamp will be installed and touch up affected area with chemical film material (Alodine 1200 or 1201) per MIL-C-5541.
- 4) Install AN742D36 Clamp complete with MS9165-05 per Section A-A of Figure 1 of this service instruction.
- 5) Touch up paint as required per Item 5.3.3 of ICA-D206-667.
- 6) Seal edges where AN742D36 Clamp meets with crosstube using Sikaflex-241/291 or MIL-S-8802 Class B2 or Proseal 890 sealant.
- 7) Install/re-install forward crosstube in accordance with Section 32.2 of ICA-D206-667.
- 8) Fasten OEM grounding strap to MS9165-05 Angle Bracket on forward crosstube per Bell instructions.
- 9) Undertake a resistance check between a ground point on the skidtube and aircraft ground in accordance with Class R-II requirement per BHT-ELEC-SPM. Maximum resistance is 10 milliohms (mΩ).


PARTS LIST:






QTY -017	PART NUMBER	DESCRIPTION
X	D206-667-017	GROUNDING STRAP INSTALLATION
2	AN742D36	CLAMP
2	MS9165-05	ANGLE BRACKET
2	MS21042-3	NUT
2	MS27039-1-08	SCREW
4	NAS1149C0332R	WASHER

WEIGHT AND BALANCE

There is a negligible weight change associated with the installation of this kit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)
DATE: 11.02.25
CERT. NO.: SH01-5
ISSUE NO.: 3

A	NEW ISSUE	MB	11.02.18
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9544	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		GROUNDING STRAP INSTALLATION	NTS
DATE	11.02.18	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>																								
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>																								
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>																								
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector																		
Doc/Data <input type="checkbox"/>																											
Equip/Tooling <input type="checkbox"/>																											
Operator <input type="checkbox"/>																											
Material <input type="checkbox"/>																											
Setup <input type="checkbox"/>																											
Other <input type="checkbox"/>																											
Process <input type="checkbox"/>																											
Supplier <input type="checkbox"/>																											
Training <input type="checkbox"/>																											
Unapproved <input type="checkbox"/>																											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

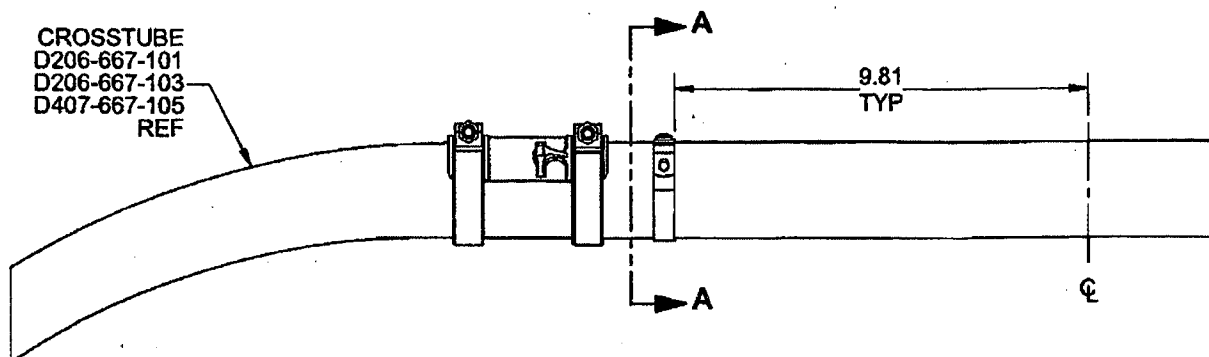
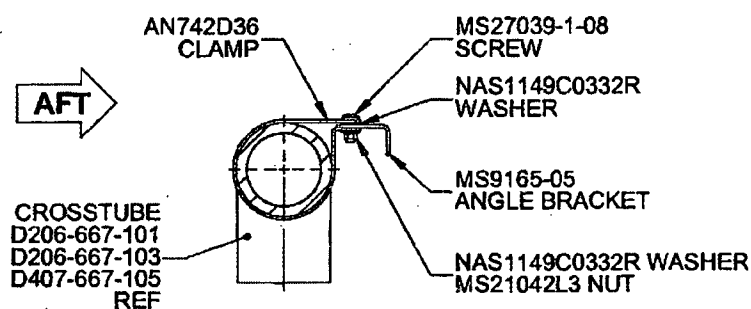


FIGURE 1 - GROUNDING STRAP INSTALLATION
(VIEW LOOKING FWD)








SECTION A-A
(SUPPORT, CLAMP, CUSHION NOT SHOWN FOR CLARITY)
TYP, 2 PL PER CROSSTUBE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 11.02.25
CERT. NO.: SH01-5
ISSUE NO.: 3

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9544	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		GROUNDING STRAP INSTALLATION	NTS
DATE	11.02.18	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data <input type="checkbox"/>									
Equip/Tooling <input type="checkbox"/>									
Operator <input type="checkbox"/>									
Material <input type="checkbox"/>									
Setup <input type="checkbox"/>									
Other <input type="checkbox"/>									
Process <input type="checkbox"/>									
Supplier <input type="checkbox"/>									
Training <input type="checkbox"/>									
Unapproved <input type="checkbox"/>									

FAULT CATEGORY

Landing Gear -	General	Other
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misabeled
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions
		<input type="checkbox"/> Ovalized
		<input type="checkbox"/> Over/Under tolerance
		<input type="checkbox"/> Part Incorrect
		<input type="checkbox"/> Part Lost/Missing
		<input type="checkbox"/> Part Moved
		<input type="checkbox"/> Positioned Wrong
		<input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced
		<input type="checkbox"/> Temperature/Cure
		<input type="checkbox"/> Weld
		<input type="checkbox"/> Wrong Stock Pulled
		<input type="checkbox"/> Other



LIQUID PENETRANT TEST REPORT

P- 12679

CLIENT DAVE AEROSPACE DATE 06-30-2004 PAGE 1 OF 1
ATTENTION ANDY / CHANTAL ACUREN JOB NO. 100-12-CO390 TIME AM ☒ PM ☐
ADDRESS 1270 ABEL DEEN STREET. PO/NO. —
WALKER BURY, ON. WORK LOCATION LANE
ACCEPTANCE STD. ASTM 1417/051-038 REV./DATE 2005
PROJECT F.P.I. ON CROSS TUBES
ITEM(S) EXAMINED (5)

JOB DESCRIPTION PROCEDURE NO. LT 1002 REV./DATE 2008 TECHNIQUE NO. LT 1002 REV./DATE 2008
PART NO. SEE RESULTS MATERIAL Aluminum THICKNESS Various
SCOPE A DET FLUORESCENT DYE PENETRANT WAS USED ON THE
100% OF THE SURFACE FOR INSPECTION

TEST DETAILS

METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND MAGNA FLEX BLACK LIGHT S/N 10459 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT 2607 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER H₂O MINIMUM DRY TIME > 10 MIN. OTHER LABINO
DEVELOPER SKD 32 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N 1098566 CAL DUE DATE 11-24-02
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE

SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < - 4°C/ 20°F ☐ - 4°C/ 20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

CROSS TUBES #				
1	"	"	90714	✓
1	"	"	84260	✓
1	"	"	84261	✓
1	"	"	90753	✓
1	"	"	92225	✓

S12/10/30

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE Andy Sheldon DTR # E-120253
TECHNICIAN (SIGNATURE): Mike Liffers REPORT REVIEWED BY:
NAME (PRINT): Mike Liffers NAME INITIALS
CGSB LEVEL 1 SNT LEVEL — CGSB LEVEL — SNT LEVEL —
CGSB REG. No 16006 CGSB REG. No —

DART AEROSPACE LTD.

IIN-D206-667
Page 17 of 19

5.0 PARTS LIST

5.1 HIGH GEAR CROSSTUBES

Item	Qty -101	Qty -201	Qty -103	Qty -203	Qty -105	Qty -205	Part Number	Description
	X						D206-667-101	CROSSTUBE INSTALLATION, 206A/B HIGH FWD
		X					D206-667-201	CROSSTUBE INSTALLATION, 206A/B HIGH AFT
			X				D206-667-103	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH FWD
				X			D206-667-203	CROSSTUBE INSTALLATION, 206L/L-1/L-3/L-4 HIGH AFT
					X		D407-667-105	CROSSTUBE INSTALLATION, 407 HIGH FWD
						X	D407-667-205	CROSSTUBE INSTALLATION, 407 HIGH AFT
1	1						D206-667-141	CROSSTUBE ASSEMBLY, 206A/B HIGH FWD
2		1					D206-667-241	CROSSTUBE ASSEMBLY, 206A/B HIGH AFT
3			1				D206-667-143	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH FWD
4				1			D206-667-243	CROSSTUBE ASSEMBLY, 206L/L-1/L-3/L-4 HIGH AFT
5					1		D407-667-145	CROSSTUBE ASSEMBLY, 407 HIGH FWD
6						1	D407-667-245	CROSSTUBE ASSEMBLY, 407 HIGH AFT
10	*2	*2	*2		*2		D2891-1	SUPPORT
11				*2			D2892-1	SUPPORT
12						*1	D2894-1	SUPPORT
13	*4	*4	*4		*4		D3595-063-395	RUBBER CUSHION
14				*4			D3595-063-450	RUBBER CUSHION
15						*2	D3595-075-430	RUBBER CUSHION
16	*4	*4	*4		*4		MS21920-20	CLAMP
17				*4		*4	MS21920-22	CLAMP
18						*2	MS21920-25	CLAMP (OR MS21920-24)
19	4	4	4	4	4		AN5-32A	BOLT
20				4		4	AN5-34A	BOLT
21	4	4	4	4	4	4	MS21042L5	NUT (OR MS21042-5)
22	8	8	8	8	8	8	NAS1149C0563J	WASHER (OR AN960JD516)
23						*2	D3190-1	CHAFING SHIELD
40	*2		*2	*2	*2	*2	D2873-043	NUT PLATE
41	*2		*2	*2	*2	*2	D2873-045	NUT PLATE
42		2					D2872-043	NUT PLATE
43		2					D2872-045	NUT PLATE
44	10		10				AN5-7A	BOLT
45		10		10	10	10	AN5-10A	BOLT
46	4	10	4	4	4	4	AN5-30A	BOLT
47				4		4	AN5-32A	BOLT
48			12				AN970-4	WASHER (OPTIONAL)
49		6					MS21042L5	NUT (OR MS21042-5)
50	10	12	10	10	10	10	NAS1149C0563J	WASHER (OR AN960JD516)
60		1					D3039-3	CENTER DRILL (TOOLING, NOT INSTALLED)

*REFERENCE ONLY. PARTS ARE INCLUDED IN D206-667-141/-143/-241/-243 & D407-667-145/-245
ASSEMBLIES ABOVE

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